

160012

Work Order ID 69658

Monday, May 16, 2011 9:16:04 AM



Item ID: D206-642-311BL

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 5/16/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-642	Rev N

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

Sulozly

For CL 11-7-6

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/7/78

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Sulozly

B7D938

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D206-642-311BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311 Location: _____ PPP Rev: _____								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

4/17/14

11/7/14

mf
11-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011


Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:J05.10.11 Added D3429-1 per CHG004KJ/CP/JLM/EC
 IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
 IPP Rev:L 08-09-29 as per DS19421 DD verified by:EC IPP Rev:M
 as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341		Manufactured	No			110	Each	3.0000	1	1			
													
Replacement Skidtube													

Location	Loc Qty	Loc Code
----------	---------	----------


FG082	3	
36550	1	
44043	1	
44044	1	

D206-648-013		Manufactured	No			110	Each	10.0000	1	1			
													
GHW Modification													

Location	Loc Qty	Loc Code
----------	---------	----------

FG120	10	
67596	6	
68347	4	

ATTN: D3414-041 - BLUE

D2932-1		Manufactured	No			110	Each	4.0000	1	1			
													
Saddle LH Out, 206													

Location	Loc Qty	Loc Code
----------	---------	----------

ST421	2	
67259	2	
ST428	2	
67790	2	

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-1
Saddle LH In, 206

Manufactured No 110 Each 4.0000

Location Loc Qty Loc Code

ST421 4
67260 4

BLUE
D2938-1
Saddle LH Out, 206

Manufactured No 110 Each 4.0000

Location Loc Qty Loc Code

ST421 4
67261 4

BLUE
D2939-1
Saddle LH In, 206

Manufactured No 110 Each 5.0000

Location Loc Qty Loc Code

ST421 3
67262 3
ST428A 2
67674 2

BLUE
AN3-41A
Bolt

Purchased No 110 Each 273.0000

Location Loc Qty Loc Code

ST354 273
112431 1
115936 72
116191 200



1

1

1

1

8

11/7/17

Monday, May 16, 2011 9:16:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110 Each

224.0000

16 16



Bushing



368102

Location

Loc Qty

Loc Code

FG 44

31985 44

ST019 180

67756 180

MS21042L3

Purchased No

110 Each

2,247.000

8 8



Nut



8

Location

Loc Qty

Loc Code

ST300 2247

116391 11

116540 270

116549 766

117441 800

117601 400

AN960JD10

NAS1149D0363J

Purchased No

110 Each

0.0000

8 8



Washer

AN5-10A

Purchased No

110 Each

180.0000

4 4



Bolt



1117291

1116704

Location

Loc Qty

Loc Code

ST337 180

117313 180

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-11A Purchased No

110 Each 92.0000



Bolt



4 4

Location

Loc Qty

Loc Code

ST337

92

117313

92

AN960JD516 NAS1149D0563J Purchased No

110 Each 0.0000



Washer



8 8

AN4-6A Purchased No

110 Each 1,153.000



Bolt



12 12

Location

Loc Qty

Loc Code

ST356

953

115936

153

116400

400

116924

400

ST358

200

117514

200

AN960JD416 NAS1149D0463J Purchased No

110 Each 0.0000



Washer



25 25

MS21042L4 Purchased No

110 Each 4,957.000



Nut



12 12

Location

Loc Qty

Loc Code

ST300

4957

114718

2

116823

1155

117441

3000

117601

800

12

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

19.0000



Tow Ring

1 1
B69662 SP

Location	Loc Qty	Loc Code
ST420	2	
66386	2	
ST464	17	
64071	7	
68339	10	

BLUE

D3456-1

Manufactured No

110 Each

73.0000



Washer

1 1
B71033 SP

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST054	66	
66848	6	
68748	60	

D3457-1

Manufactured No

110 Each

40.0000



Washer

2 2
B70774 11/7/11 SP

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST054	30	
67779	30	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,304.000

1

1



Nut

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST300	600	
117423	600	
ST301	664	
116188	-12	
116549	176	
117601	500	

AN4C5A

Purchased

No

110

Each

530.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP-B	115	
112243	115	
ST345	415	
112243	415	

AN960C416

NAS1149C0463
R

Purchased

No

110

Each

0.0000

1

1



washer



M117735

11/7/7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

34.0000



Ring

Location

Loc Qty

Loc Code

ST420

19

62961

8

66387

11

ST473

15

65294

1

66945

14

BLUE

D2712

Manufactured No

110 Each

451.0000



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

252

66955

252

ST021

149

65115

149

D2934

Manufactured No

110 Each

38.0000



Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

32

67585

32

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 8

Work Order ID: 69658

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/16/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

56.0000

2



Saddle Spacer



11/7/7

Location

Loc Qty

Loc Code

ST027

56

66564

56

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09